

Date: Friday, 27/02/2009 11:51:42 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOCK BRACKET
Job Number	: 46115		
Estimate Number	: 13360		
P.O. Number	:	Part Number	: D37061
This Issue	: 27/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3706 REV.A
First Issue	: / /	Project Number	: N/A
Previous Run	: 05023	Drawing Revision	: A
	Type	Material	:
	: MACHINED PARTS	Due Date	: 06/03/2009
Written By	:	Qty:	5
Checked & Approved By	: <u>JUL 09.02.27</u>	Um:	Each
Comment	: Est Rev:A New Issue 08-06-04 JLM Verified By:EC Est Rev:B 09-02-20 rev.a as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .750 X 1.50
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Comment: Qty.: 0.3056 f(s)/Unit Total : 1.5278 f(s)

6061-T6 Bar .75" X 1.5"

BATCH: M110167

N.A 09/03/06

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank 3.625" long

N.A 09/03/06

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #11- Mill as per Folio FA805 Rev: A & Dwg D3706 Rev: A

⑤

2-Deburr per dwg D3706

mmf 09/03/16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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⑤

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/03/16

5.0	QC8	SECOND CHECK
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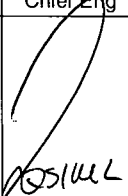
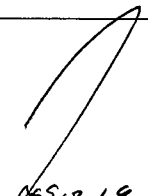

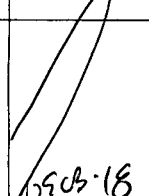
**Comment:** SECOND CHECK

N.A 09/03/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3706-1 PAR #: N/A Fault Category: Prod / Machined Part NCR: Yes No DQA: PD Date: 05/03/06
D3705-043/041 D410-761-047
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: PD Date: 07/03/06

NCR: <u>46115</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/15	3.0	Program fault, Tool ran into part. R.C: program error.		scrap! Replace Qnt: 1 Batch # M110/67 New Prog. Test in Retract was too Low. Fixed Prog.	mmf 09/03/15			

NOTE: Date & initial all entries

Date: Friday, 27/02/2009 11:51:42 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK BRACKET

Job Number: 46115

Part Number: D37061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



5K

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 129

9/3/20

50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46115
Description: Lock Bracket		Part Number: D3706-1
Inspection Dwg: A	Rev: A	Page 1 of 1

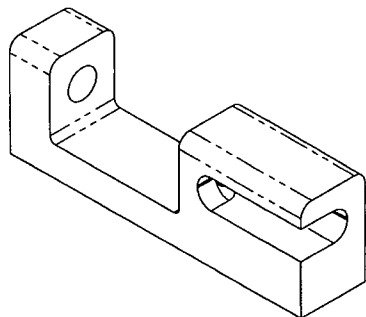
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

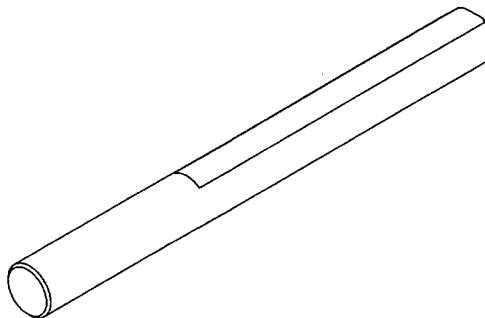
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	$\pm .010$	1.500	✓			
.460	$\pm .010$.460	✓			
.80	$\pm .03$.80	✓			
R .06	$\pm .03$	R .06	✓			
R .156	$\pm .010$	R .156	✓			
3.38	$\pm .030$	3.37	✓			
1.20	$\pm .03$	1.20	✓			
.75	$\pm .03$.74	✓			
Ø .328	$^{+.006}_{-.001}$	Ø .330	✓			
1.15	$\pm .03$	1.14	✓			
.745	$\pm .010$.739	✓			
.375	$\pm .010$.371	✓			
.334	$\pm .010$.333	✓			
1.20 DEEP	$\pm .010$	1.123	✓			
R .130	$\pm .010$	R .125	✓			

Measured by: mmf	Audited by: H.A	Prototype Approval:	N/A
Date: 09/03/16	Date: 09/03/19	Date:	N/A

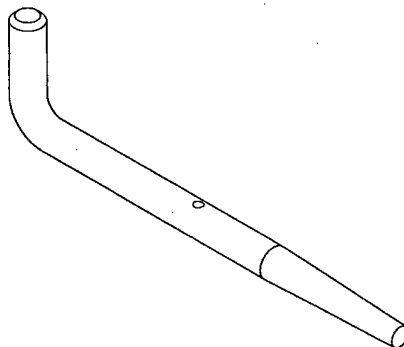
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3706-1 LOCK BRACKET



D3706-3 GUIDE



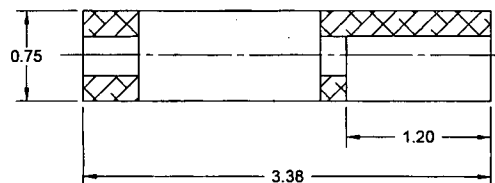
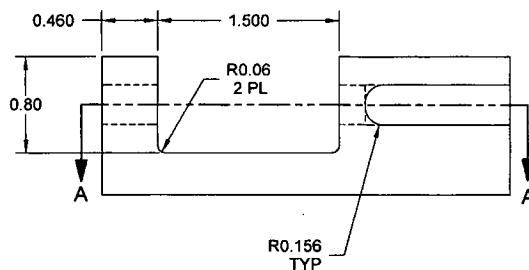
D3706-5 PIN

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WITHOUT NOTICE
WORK ORDER
NO. 40113

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09/02/05 MPA

REV.	NEW ISSUE	DESCRIPTION	MB	08.05.26
DESIGN			BY	DATE
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CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.26			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3706	REV. A SHEET 1 OF 4
TITLE INSTRUMENT PANEL LOCK	SCALE NTS
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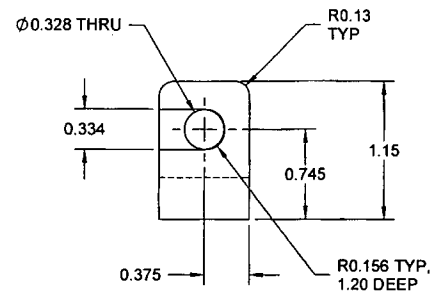
SECTION A-A

D3706-1 LOCK BRACKET

NO. 4611
 WORK ORDER
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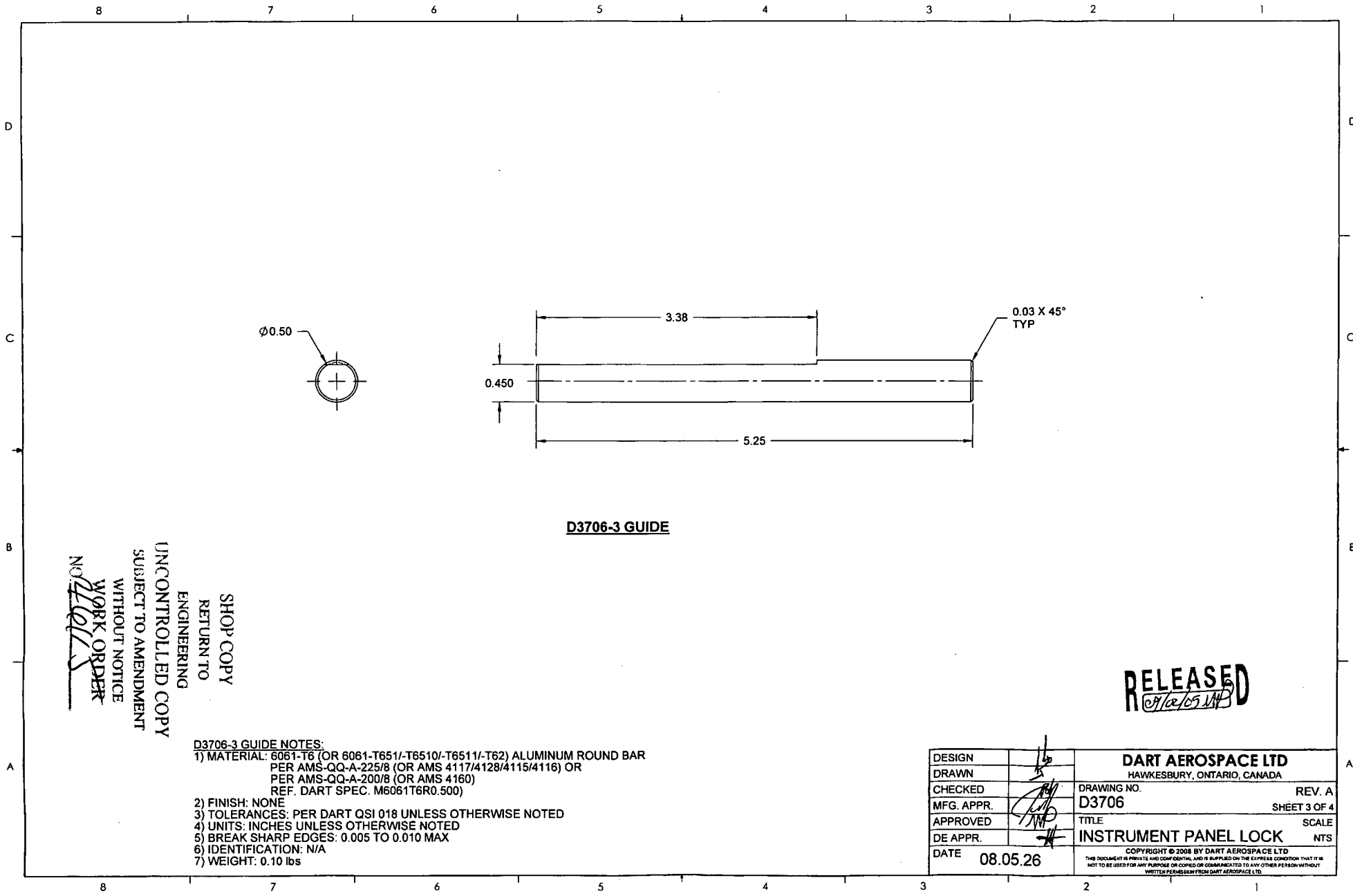
D3706-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs



RELEASED
 8/12/05 NPB

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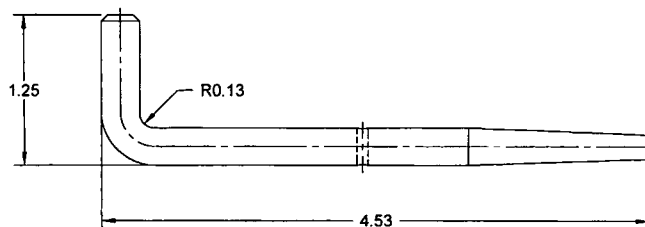
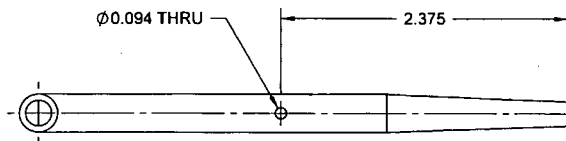
D3706-3 GUIDE

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 WORK ORDER
 NO. 21615

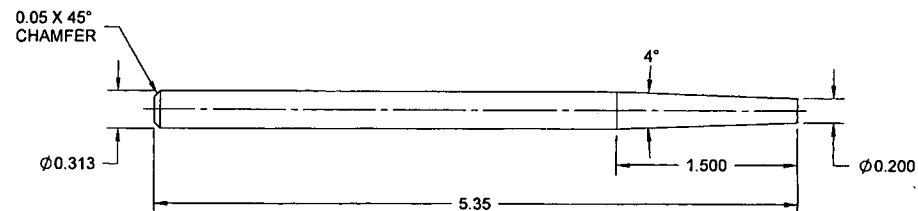
- D3706-3 GUIDE NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) ALUMINUM ROUND BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF. DART SPEC. M6061T6R0.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs

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 09/02/05 VAP

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D3706-5 PIN
(MAKE FROM D3706-5F)



D3706-5F PIN

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 71015

D3706-5 NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
(REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

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